



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3205-00E
Job Sheet 173851



Part No: RBE350A93-3205-00E

Job Qty: 6 ea

Part Name: Engine G/B Input Flange Holding Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3205-00E Rev 2A IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/14/18	0.00	0.00	Start Up Waterjet		pc 18/03/21
100	Waterjet	6 pcs		4/14/18	0.00	0.60	Waterjet 2 OMAX		pc 18/03/21
110	QC	6 pcs		4/14/18	0.00	0.00	QC2 Waterjet-4		pc 18/03/21
120	Mori Seiki	6 pcs		4/16/18	0.00	6.00	MORI NV5000-2		J.L.-L
130	QC	6 pcs		4/16/18	0.00	0.00	QC2-2		J.C.-L. 18-05-10
140	QC	6 pcs		4/16/18	0.00	0.00	QC8		pc 18-05-15
170	Outsource	6 pcs		4/28/18			Altech ATG001-VC	10	CTIB-5-30
180	Packaging	6 pcs		4/28/18	0.00	0.00	Packaging2		At 18/06/07
190	QC	6 pcs		4/28/18	0.00	0.00	QC6		38
191	Small Fab	6 pcs		4/28/18	0.00	1.20	Small Fab-3		MLC 9-89 DAS
192	QC	6 pcs		4/28/18	0.00	0.00	QC5		38
206	Packaging	6 pcs		4/28/18	0.00	0.00	Packaging3-2		SP18-06-22 GA140
210	QC21-FG	6 Ea		4/28/18	0.00	0.00	QC21		21 JUN 22 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary

Descriptions: 120 - 1-Machine as per folio FB743 FOLIO REV: DWG REV: 2-Deburr 3-Engrave T/N

And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ALTECH: PO 010044 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A

191 - Pick, bag and tag. ***See engineering for hardware sign off. WAS AN315-5, IS AN315-5R***

206 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	2.4000 sf (.4 ea)	90-Start up Operation	
AN315-5R	Nut 5/16-24	18 Ea (3 ea)	191-Small Fab	5036473
AN5-7009 2'	Hex Head Cap Screw	18 Ea (3 ea)	191-Small Fab	5036472 14x
NAS1149F0563P 2604	Washer	18 Ea (3 ea)	191-Small Fab	5054114

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.250	2	42	0
191-Small Fab	AN315-5R	18	134	0
	AN5-7	18	114	0
	NAS1149F0563P	18	149	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor
Approval Verification _____QC / QA Coordinator
Approval _____
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA S13 6S2 - 6200
TEL: sales @ dartaero.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S054079
Part: RBE350A93 - 3205 - 00E

Job No: 173851
Serial No/Batch: S054079

Revision: 2A
Inspector: _____

Date: 03/22/18

Root Cause

Environment ☐	No Re-verification ☐		DART AEROSPACE Container No: S054079 Part: RBE350A93 - 3205 - 00E Job No: 173851 Serial No/Batch: S054079 Revision: 2A Inspector: _____	Unacquainted ☐	Positioned Wrong ☐
Design ☐	Operator ☐				Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐				Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐				Part Incorrect ☐
Handling/Pre ☐	Training ☐				Part Lost/Missing ☐
Material ☐	Use for Testing ☐				Part Moved ☐
Internal Transport ☐	Poor Information ☐				Drawing ☐
Tribal Knowledge ☐	Rushing ☐				Finish ☐
LOA ☐	Product Improvement ☐				Misread ☐
Substation ☐	Process Improvement ☐				Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
OTHER : _____					

Part Specifications

Specifications could not be found.

Plex 3/8/18 7:45 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040044**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040044
PO Date: 5/30/18
Due Date: 6/1/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173888	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to Groupe Altech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	6/1/18	8 pcs	0 pcs	8 pcs	\$4.50/pcs	\$36.00

Line Item Note ** Rush part - need back by Friday (6/1/18) **

2	173854	RBE350A93-3302-02-1	Handle -Issue P/O to Groupe Altech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	6/1/18	12 pcs	0 pcs	12 pcs	\$9.75/pcs	\$117.00
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Line Item Note ** Rush part - need back by Friday (6/1/18) **

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	173851	RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench -Issue P/O to Groupe Altech : PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A	Firmed	6/1/18	8 pcs	0 pcs 8x	8 pcs	\$4.50/pcs	\$36.00 AT 18/06/107
Line Item Note ** Rush part - need back by Friday (6/1/18) **										
4	178268	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	6/1/18	33 pcs	0 pcs 33x	33 pcs	\$4.16/pcs	\$137.28 AT 18/06/107
Line Item Note ** Rush part - need back by Friday (6/1/18) **										
									Grand Total:	\$326.28
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

DA6
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9-88

Plex 5/31/18 3:39 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(009853-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

009853 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Jun-2018		Aman		040044				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
3	RBE350A93-3205-00E Rev.	RBE350A93-3205-00E ANODIZE RED PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
4	646.3912 Rev.	646.3912 CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2	CADMIUM CH	33	33	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.